Tuesday, 29/07/2008 4:56:34 PM

Julie Lecoca

Process Sheet

Customer **Job Number** : CU-DAR001 Dart Helicopters Services

: 40789 : 13513

Estimate Number

P.O. Number

This Issue

Previous Run

: 29/07/2008 : NC

Prsht Rev. First Issue

: //

Type

S.O. No. :

Part Number

Drawing Name

: D21981

: BRACKET

Drawing Number

: D2198 REV C

Project Number

: N/A : C **Drawing Revision**

Material

Due Date

: 08/08/2008

Qty:

10 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev:A

: SMALL /MED FAB

08-07-24 new issue ec verified by:dd

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

304/316 Sheet .063

M304S16GA

Comment: Qty.: 0.1313 sf(s)/Unit

Total: 1.3125 sf(s)

304 SS Sheet 0.063" thick

batch: 108734

2.0

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2198

Dwg Rev:____________ Prog Rev:_

2-Deburr if necessary

3.0



B 8-6-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: SECOND

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Bend as per dwg D2198



Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr,	Approval QC Inspector
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Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	
			QA: N/C	Closed:	Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Approval	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Tuesday, 29/07/2008 4:56:34 PM Date: Julie Lecocq User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BRACKET Job Number: 40789 Part Number: D21981 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Identify wiith Part part # using a fine point permanent marker and Stock Location: QC21 FINAL INSPECTION/W/O RELEASE 8.0 1 08/08/269 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

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W/O:				WORK ORDER	CHANGES				ļ.	
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Part No	:	F	AR #:	Fault Category:	NCR	R: Yes	No DQ	A :	_ Date:	
						QA: N	N/C Close	d:	_ Date: _	

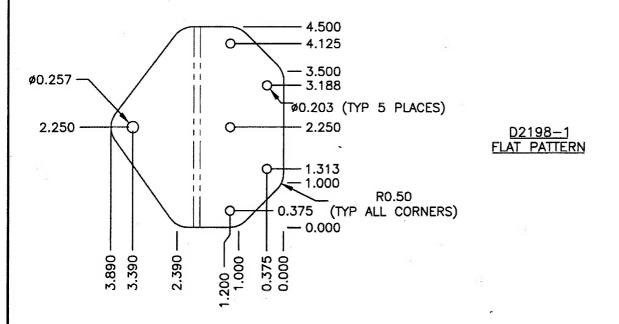
NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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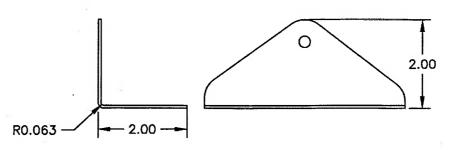
NOTE: Date & initial all entries





DESIG	#	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECK	#	APPROVED	DRAWING NO. D2198	REV. C SHEET 1 OF 1
DATE			TITLE	SCALE
03.0	5.28		BRACKET	1:2
В		93.10.05	REDESIGN	
С		03.05.28	REDRAW	





D2198-1 BRACKET BEND DETAIL

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

D2198-1

- MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)
- FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.005 TO 0.015

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-DART-REROSPACE LTD	Work Order:	40789
Description: BRACKET	Part Number:	D9148-1
Inspection Dwg: 1)2198-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Q ,303	1005001	F061	x			
T26. \$	100 200.+	1362	×			
357	4- ,010	(357	×			
1.313	7010	1,315	Ø			
2.750	4- 010	3.355	مح			
3.188	t/ao	3.195	X			
4.175	4010	4.176	ðs र			.1
4.500	4010	4.496	A			
	7010	371)e			
1.700	.010	1.204	<u>ک</u>			
3.396	4010	3,391	8			
	th -010	3.892	×			
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Measured by:	B	Audited by:	5, ,	Prototype Approval:	A	
Date:	8-8-6	Date:	208080	Date:		<u>r</u>

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

